

Work Order ID 117601-3

Split

117601

Page 1

Monday, April 28, 2014 1:44:01 PM

Item ID: D2855-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

8

Item Name: Cap

Stop *NS2*

Start Date: 4/28/2014

Start Qty: 50.00

50

Cust Item ID:

Required Date: 5/19/2014

Req'd Qty: 50.00

50

Customer:

Reference:

Approvals:

Process Plan: CZ

Date: 14/04/28

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2855	Rev B								
100	PURCHASING	0.00							
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: 24003								
	Cast per Dwg D2855								
	Material Release Note Required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.00							
Packaging	Ensure Material Release Note is attached								
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS

27

9-89

0.00

14/6/13

POSITIVE RECALL

RECEIVED 14/06/13

AUTH

u Certs

RECEIVED

DATE

14/06/13

Work Order ID 117601

Monday, April 28, 2014 1:44:01 PM

117601

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Item ID: D2855-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cap
 Start Date: 4/28/2014 Start Qty: 50.00 *50* Cust Item ID:
 Required Date: 5/19/2014 Req'd Qty: 50.00 *50* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab	Small Fab	0.00							
	Memo	0.00							
	1- Drill as per Dwg D2855 using DT8235 2- Open holes to 19/64" 3- Cut to length as per dwg 4- Deburr								14/06/17 DAS 44 9-89
140 *140* QC	QC5- Inspect part completeness to spec on W/O	0.00							
	Memo	0.00							88
150 *150* Powdercoat	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
	Memo	0.00							8 14-6-19 DAS 34 9-89
	START TIME: 8:25 OVEN TEMPERATURE: 320° FINISH TIME: 8:55								

Work Order ID 117601

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117601

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Item ID: D2855-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cap
 Start Date: 4/28/2014 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 5/19/2014 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				8x	d	41	14/07/01
170 *170* Small Fab Small Fab Small Fab	Small Fab Memo Install Inserts as per Dwg D2855	0.00 0.00				8x	f	41	14/07/04
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				8x	H-7-H		

DAS
15
9-89

DAS
34
9-89

Work Order ID 117601

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117601

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Item ID: D2855-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Cap

Stop ***NS2***

Start Date: 4/28/2014 Start Qty: 50.00

50

Cust Item ID:

Required Date: 5/19/2014 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: <u>FR-001</u> Memo	0.00 0.00				<u>vs</u>	<u>d</u>	<u>sd</u>	<u>4/27/04</u>
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				<u>MLS</u>	<u>1407-04</u>		<u>MF</u> <u>14-7-4</u>

Picklist Print

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Page 1

Work Order ID: 117601

117601

Parent Item: D2855-3

D2855-3

Parent Item Name: Cap

Start Date: 4/28/2014

Required Date: 5/19/2014

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AKS7-1032-225	AELS8-1032-225	Purchased	No			170	Each	1,177.000	2	100			

AI S7-1032-225

Insert

**

Ak94-1032-225

Location

Loc Qty

Loc Code

FG	80	
118520	80	
FP001	1000	
m128649	1000	
ST280	97	
m128179	97	

D2855P

Purchased

No

110

Each

0.0000

1

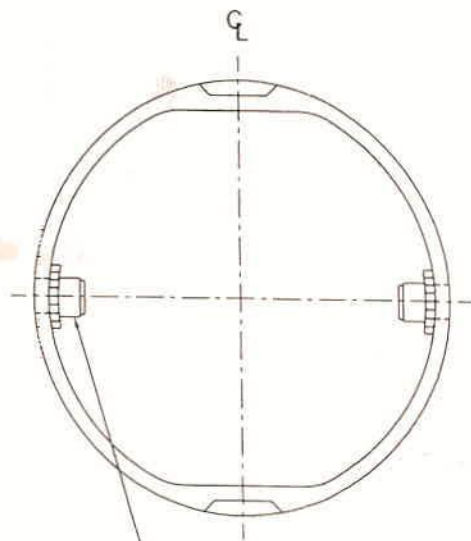
50

D2855P

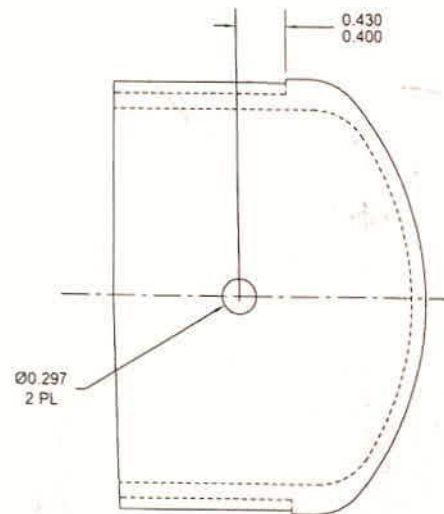
Cap

**

CD 14/06/02 30



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL



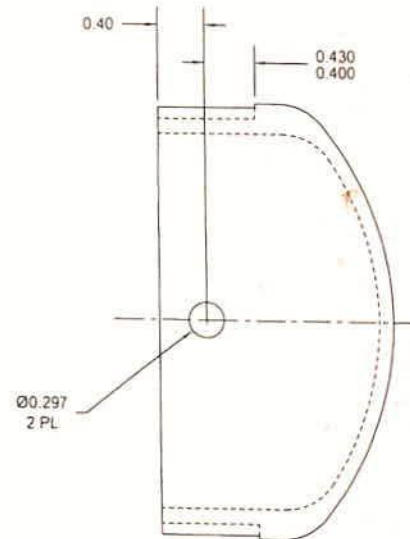
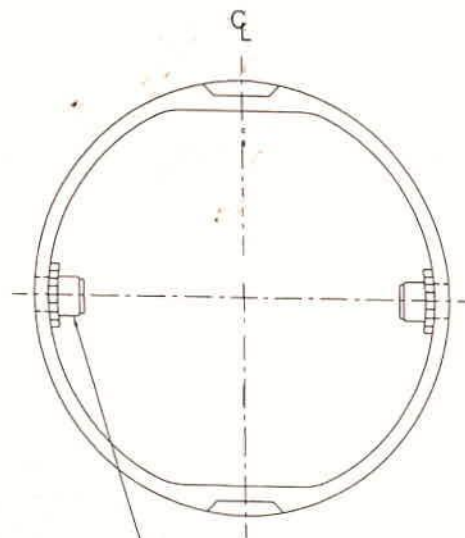
D2855 CAP
(MAKE FROM D2855C CASTING)

RELEASED
9/6/15

NOTES:

- 1) MATERIAL: MAKE FROM D2855C
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.63 lbs

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO	REV. B
MFG. APPR	RF	D2855	SHEET 2 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR	RF	CAP	NTS
DATE	09.06.30	COPYRIGHT © 1996 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS UNCLASSIFIED AND CAN BE RELEASED TO THE PUBLIC. NO COPYRIGHT CLAIM IS MADE. IT IS NOT TO BE USED FOR ANY PURPOSES OR FOR ANY COMMERCIAL OR OTHER PURPOSES WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

D2855-3 CAP 
(MAKE FROM D2855C CASTING)

RELEASED
[Signature]

NOTES:

- 1) MATERIAL: MAKE FROM D2855C OR D2855
- 2) FINISH: POWDER COAT "WHITE" (4.3 5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.50 lbs

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG APPR	<i>[Signature]</i>	D2855	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CAP	NTS
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO24003

Purchase Order Date 4/29/2014

PO Print Date 5/1/2014

Page Number 1 of 2

Order From :
METALLURGIE SYCA
500 PRINCIPALE
ST.DOMINIQUE, QUEBEC JOH 1LO

VC-MSY01

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED \$

Contact Name
Vendor Phone 450-261-0853
Ship To Contact
Ship To Phone
Ship Via: FedEx PI collect
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

FORMED 05/10/2014

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2855P CAST AS PER DWG D2855 REV. B B117602	Cap ✓	5/23/2014 Yes 5/23/2014		50.00 Each <i>NCC 55</i>	\$12.50	\$625.00
						Line Total:	\$625.00
2	D2855P CAST AS PER DWG D2855 REV. B B117601 <i>14/06/02</i>	Cap ✓	5/23/2014 Yes 5/23/2014		50.00 Each <i>NCC 56</i> <i>10/4/13</i>	\$12.50	\$625.00
						Line Total:	\$625.00

Note:

5/1/2014

N° D'ENR. DE TAXE
TAX REG. NO.

N° DE COMMANDE
ORDER NO.

VENDU À
SOLD TO

ADRESSE
ADDRESS

EXPÉDIÉ À
SHIP TO

ADRESSE
ADDRESS

DATE

30 Mai 2014

24003

Dart Aerospace Ltd

1270 ABERDEEN STREET

HAWKSBURY ONTARIO

K6A 1K7

DATE D'EXPEDITION
SHIPPING DATE

VIA

CONDITIONS
TERMS

ACHETEUR
BUYER

VENDUEUR
SALESPERSON

111

D-2855

1 BOITE X 55 PCS X 30 POUNDS

1 BOX X 56 PCS X 31 POUNDS

Transport Fedex

Thanks for your support

TOTAL

931352

SIGNATURE

BlueLine DCB27

FORMULAIRE DE VENTE - SALES ORDER

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MÉTALLURGIE SYCA Inc.

500, Principale
St-Dominique, Québec

JOH 1LO

Tél: (450) 261-0853

Fax: (450) 261-0894

E-mail: syca@qc.aira.com

WWW.SYCA-INC.COM

CERTIFICATE OF COMPLIANCE

COMPANY: DART AEROSPACE LTD
1270, ABERDEEN STREET
HAWKSBURY, ONTARIO
K6A 1K7

DATE: 2014-05-30

SHIPPING MEMO: 931125

TRANSPORT: VIA FEDEX COLLECT

NUMBER OF PAGES: 2

DESCRIPTION	QUANTITY	PART CODE	P.O NUMBER
CAP D-2855	111	D-2855	24003

All item specify in this compliance certificate are manufactured in Canada.

-PRODUCTION LOT: KJJ21052014

-ALLOY: A-356

-NORME: ASTM B-85

-CHEMICAL ANALYSIS: SUPPLY

-VISUAL INSPECTION: DONE

-DIMENSIONNAL INSPECTION: NON-APPLICABLE

-SURFACE SMOOTHNESS : ALUMINIUM ASSOCIATION DATA

RESPONSIBLE: CARL JOBIN ING.

SA-101